

Date: Tuesday, 3/20/2007 2:28:58 PM  
User: Eric Charbonneau

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACKING PLATE		
Job Number	: 30679					
Estimate Number	: 10506					
P.O. Number	: N/A		Part Number	: D2228		
This Issue	: 3/20/2007	S.O. No. : N/A	Drawing Number	: D2228 REV. B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: 2/8/2007	Type : MACHINED PARTS	Drawing Revision	: B		
Previous Run	: 24958		Material	: N/A		
Written By	<u>E</u>		Due Date	: 2/23/2007		
Checked & Approved By			Qty:	200	Um:	Each
Comment	: Est:B 00.08.22 Re-format EC					

## Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
		
Comment: Qty.: 0.0227 sf(s)/Unit Total : 4.5400 sf(s) 5052-H32 .063 Sheet Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) Batch: m19059 ml 01 03 21 (200)		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D2228 ml 07 04 02 (200) Dwg Rev: B ml 07 03 21 Prog Rev: B		
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK ml 07 04 02 (200)		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1 M.d 07/04/04 (200x)		

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Job Number: 30679

Part Number: D2228

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



m103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

fx

07/04/04

QBS

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f

07/04/04

200X

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 7/4/05 (200)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



200

Comment: FINAL INSPECTION/W/O RELEASE

PC 7/4/05

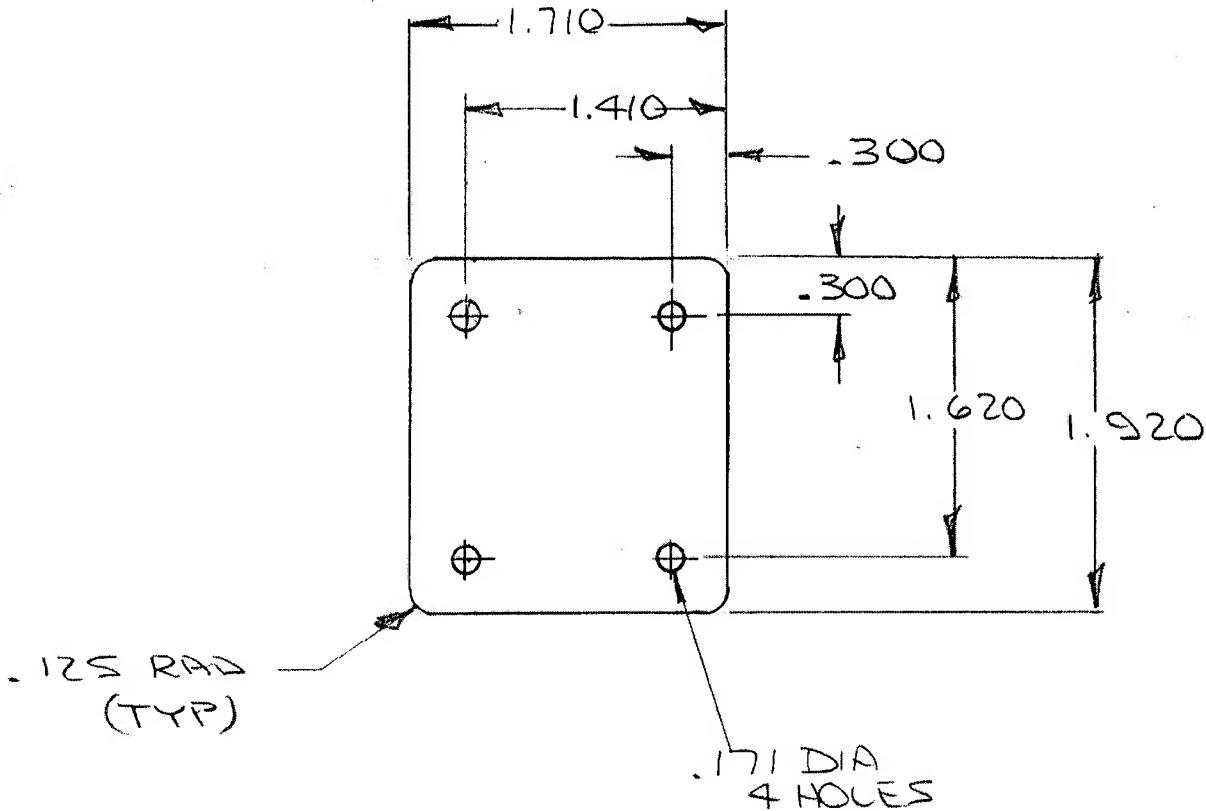
Job Completion



PC 7/4/05

**DART**

DRAWN BRADLEY 94.3.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.23	DRAWING NO. <b>D2228</b>	REV. <b>B</b>
STRESS	TITLE BACKING PLATE	SHEET <b>1</b> OF <b>1</b>
B	00.09.11	UPDATE FINISH SPEC. <del>CP</del>

**RELEASED**  
00.04.12 ~~CP~~

MATERIAL: 5052-H32 .063 THICK  
(QQ-A-250/8)

FINISH : CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30679

DART AEROSPACE LTD

Work Order: 30679

Description: ~~Bear Paw~~ Backing Plate

Part Number: D2228

Inspection Dwg: D2228 Rev: B

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## FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.171$	+0.005-0.001	0.173	✓		vern	
B 1.920	+1-0.010	1.918	✓		vern	
C 1.710	+1-0.010	1.709	✓		vern	
D 1.410	+1-0.010	1.409	✓		vern	
E 1.620	+1-0.010	1.620	✓		vern	
F 0.300	+1-0.010	0.298	✓		vern	
G 0.300	+1-0.010	0.304	✓		vern	
H R.125	+1-0.010	R.125	✓		Radius Gauge	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	<i>M. M.</i>
Date:	07/03/02

Audited by:	<i>M.</i>
Date:	07/04/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	